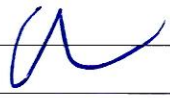


Work Order ID 155783***155783***

Page 1

Tuesday, January 24, 2017 2:27:13 PM

Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible
Start Date: 1/18/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/30/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2351-041	Rev E								
IIN-D350-591	H								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels as per PPP D350-591-121 CHG005								
110	Large Fab	0.00							
110	Large Fab	0.26							
Large Fab	Memo								
Large Fab	1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G								
	2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.								
	3-Deburr								

DAS
6
9-89

APR 04 2017

DAS
21
9-89DAS
28
9-89

APR 06 2017



Work Order ID 155783

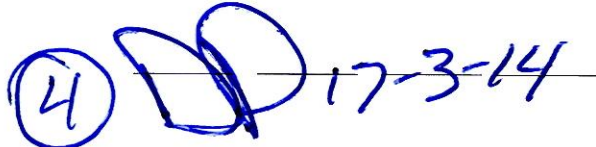
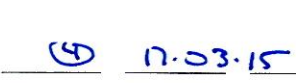
Tuesday, January 24, 2017 2:27:13 PM

155783

Page 2

Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible
Start Date: 1/18/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/30/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* CNC Bend 1 CNC Delta 100 Bender	BENDING MACHINE - SKIDTUBES Memo Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT030. Use Bend Program D2351-041.	0.05 0.09							
122 *122* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01							 
126 *126* Large Fab Large Fab	 Memo ***BUFF AND REMOVE BENDING MARKS WITHIN .005", if deeper see engineer***	0.00 0.00							 MAR 22 2017

Tuesday, January 24, 2017 2:27:13 PM

155783

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Stop

NS2

Start Date: 1/18/2017 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 1/30/2017 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				<u>4</u>			DAS 24 9-89 MAR 22 2017
140 *140* Large Fab Large Fab Large Fab	Large Fab Memo 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033 A/RAluminum Rod <u>134785</u> 3-Do not Grind top edge Flush	0.00 0.22				<u>4</u>		MAR 3 2 2017	DAS 24 9-89
150 *150* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>①</u>	<u>17.03.24</u>	<u>②</u>	

Work Order ID 155783

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155783

Page 4

Item ID: D350-591-121

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 1/18/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/30/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.01							
Quality Control									
170	Chemical Conversion Coat per QSI005 4.1	0.00							
170									
HandFinish	Memo	0.11							
Hand Finishing									
180	QC7-Inspect Chemical Conversion Coat	0.00							
180									
QC	Memo	0.01							
Quality Control									

(24) 11-03-24 PD

(x4) 201703/07
BEB4 MAR 29 2017 DAS
24
9-89

Work Order ID 155783

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Page 5

Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible
Start Date: 1/18/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/30/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Large Fab Large Fab	Large Fab Memo 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod <u>H130 835</u> 3-Grind end cap flush per dwg D2351	0.00 0.21							MAR 29 2017 DAS 24 9-89
220 *220* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				4			MAR 29 2017 DAS 38 9-89
230 *230* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				4			MAR 29 2017 DAS 38 9-89

Handwritten notes:
- 2017/04/03 (4x)
- 17/03/28
- 4x DC 2017/03/29

Work Order ID 155783

Tuesday, January 24, 2017 2:27:13 PM

155783

Page 6

Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible
Start Date: 1/18/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/30/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Chemical Conversion Coat per QSI005 4.1	0.00							
240 HandFinish Hand Finishing	Memo	0.03				<u>X4LH</u>	<u>0</u>		201703/31 BEB.
250	White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum	0.00							
250 Powdercoat Powder Coating	Memo START TIME: <u>3:35</u> OVEN TEMPERATURE: <u>300</u> FINISH TIME: <u>4:05</u>	0.12				<u>4</u>	<u>0</u>	<u>17-04-3</u>	<u>338</u>
260	Wing Walk as per dwg QSI005 4.4 Batch <u>M137092</u>	0.00							
260 HandFinish Hand Finishing	Memo	0.13				<u>X4LH</u>	<u>0</u>		201704/04 BEB

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NS1

NS2

Customer:

NR1

NR2

[illegible]

Work Order ID 155783

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Page 8

Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible
Start Date: 1/18/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/30/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00							
300									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-121 Location:FG039								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.07							
Quality Control									

DAS
27
9-89
APR 10 2017

DAS
28
9-89

DAS
21
9-89

APR 10 2017 APR 10 2017

APR 10 2017

DAS
21
9-89

APR 10 2017

Picklist Print

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Page 1

Work Order ID: 155783

155783

Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 1/18/2017

Required Date: 1/30/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E02.10.21Re-format; Incorporated D2351-041 IPPKJ/RF
IPP rev. F 06.02.23 added grinding EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116		Manufactured	No			110	Each	106.0000	0.5	3			
D2244-116									**				
Step Extrusion													

Location	Loc Qty	Loc Code
HALL	12	
117818	12	
WA003	94	
150064	94	
xxxxx	0.0000368	

D2850-1		Manufactured	No			140	Each	18.0000	1	4			
D2850-1									**				
End Bracket													

Location	Loc Qty	Loc Code
WA003	18	B144767 → 2
144767	2	
149901	16	B149901 → 2

D2582		Manufactured	No			190	Each	8.0000	1	4			
D2582									**				
Hi-Skid Step Leg Assembly													

Location	Loc Qty	Loc Code
WA003	8	B155534 → 2x
150245	3	
152238	5	B157228 → 2x

Picklist Print

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Work Order ID: 155783

155783

Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 1/18/2017

Required Date: 1/30/2017

Start Qty: 4.00

Required Qty: 4.00

MS20600-AD4W3

Purchased

No

190

Each

646.0000

16

64

MS20600-AD4W3

Cherry Rivet

**

DC 2017/04/03

Location

Loc Qty

Loc Code

CCK004

300

B136648 → 64

m136648

300

ST308

182

m135603

182

WA003

164

m135603

164

210

Each

57.0000

1

4

**

D2673-34

Manufactured

No

D2673-34

End Plate

Location

Loc Qty

Loc Code

WA003

57

148718

3

151793

8

152320

26

155298

20

290

Each

327.0000

2

8

**

APR 06 2017

AN4-16A

Purchased

No

AN4-16A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

over003

200

M136648

200

ST343

122

M135948

22

M136450

100

136740

DAS
6
9-89

DAS
27
9-89

Picklist Print

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Page 3

Work Order ID: 155783

155783

Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 1/18/2017

Required Date: 1/30/2017

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

290

Each

3,888.000

6

24

NAS1149D0463.J

Washer

APR 06 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

80

M134508

13

M135056

67

ST260a

2600

M136263

600

M136665

2000

ST263

1208

M136044

22

M136192

600

M136406

586

136838

D2230-1

Manufactured

No

290

Each

102.0000

1

4

D2230-1

Mounting Lug

APR 06 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

4

150062

2

84136

2

ST521

48

115306

1

151611

47

ST525A

50

153924

50

153924

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Shop Packet Print

Page 3

Picklist Print

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Page 4

Work Order ID: 155783

155783

Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 1/18/2017

Required Date: 1/30/2017

Start Qty: 4.00

Required Qty: 4.00

AN3-37A

Purchased

No

290

Each

58.0000

2

8

AN3-37A

Bolt

**

APR 06 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

FG
119086
over003
m136554
ST347
m135945

10
10
30
30
18
18

DAS
28
9-89

MS21042L3

Purchased

No

290

Each

2,070.000

2

8

MS21042L3

Nut

**

APR 06 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001
m135945
GA
m134360
m135135
OVER007
M136554
M136665
ST303
M136044
M136192
M136406

100
100
158
108
50
1000
500
500
812
11
301
500

DAS
28
9-89

137073

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Page 4

Picklist Print

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Page 5

Work Order ID: 155783

155783

Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 1/18/2017

Required Date: 1/30/2017

Start Qty: 4.00

Required Qty: 4.00

AN4-13A

Purchased

No

290

Each

401.0000

3

12

AN4-13A

Bolt

APR 06 2017

DAS
6
27
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	20	
122808	20	
GA	76	
m134634	19	
m135470	57	
over003	200	
m136665	200	
ST344	105	
m136263	105	

136789

MS21042L4

Purchased

No

290

Each

2,996.000

3

12

MS21042L4

Nut

APR 06 2017

DAS
6
27
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001	18	
m133363	18	
GA	187	
m135058	187	
OVER007	2000	
m136450	500	
m136648	1500	
ST303	791	
m136182	496	
m136295	295	

12

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Shop Packet Print

Page 5

Picklist Print

Tuesday, January 24, 2017 2:27:12 PM

Work Order ID: 155783

155783

Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 1/18/2017

Required Date: 1/30/2017

Start Qty: 4.00

Required Qty: 4.00

D2230-3 Manufactured No

290 Each 178.0000 1 4

D2230-3

Mounting Lug

**

APR 06 2017

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	6	
109344	4	
89045	2	
ST521	172	
151426	80	
152183	12	
153925	80	

154877x3

157193x1

D2732-030 Manufactured No

290 Each 411.0000 2 8

D2732-030

Rubber Cushion - 3"

**

APR 06 2017

DAS
6
27
9-89

Location	Loc Qty	Loc Code
FG	86	
146999	9	
149044	20	
150011	40	
151844	17	
ST410	325	
154137	125	
154138	200	

15805FX2

158348X6

NAS1149D0363J Purchased No

290 Each 927.0000 4 16

NAS1149D0363J

Washer

**

APR 06 2017

DAS
6
27
9-89

Location	Loc Qty	Loc Code
GA	233	
m134055	233	
ST263	694	
m136318	694	

136787



DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155783 MC5
1701-20

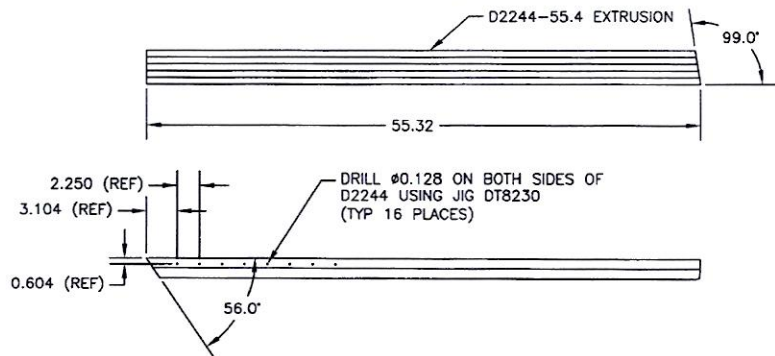
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PH
ECN 1105
UNDER REVIEW
07.11.29 [Signature]
PER NO. 263

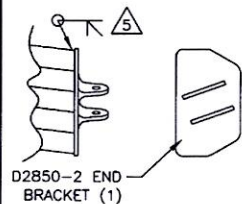
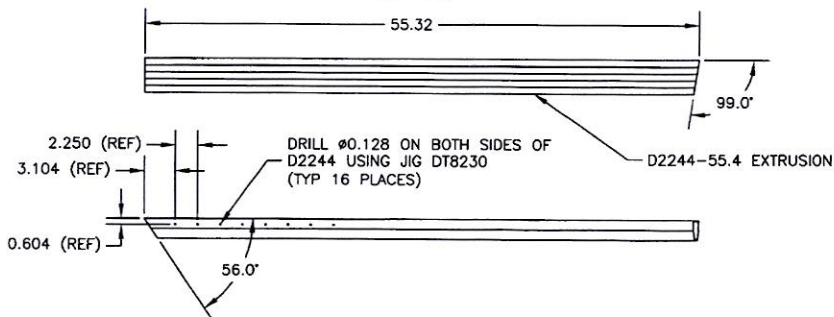
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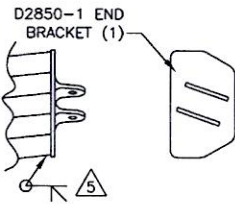
D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP



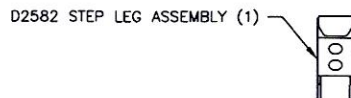
D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP



DETAIL A
SCALE: 1:4



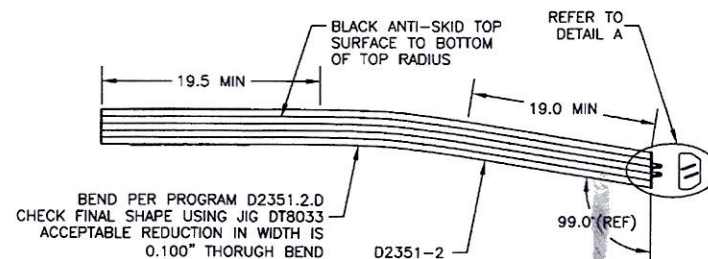
DETAIL B
SCALE: 1:4



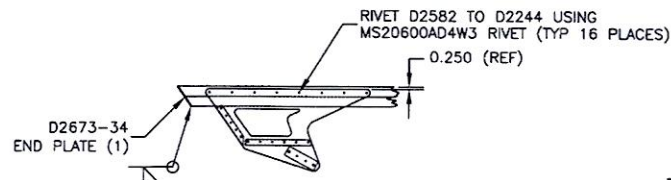
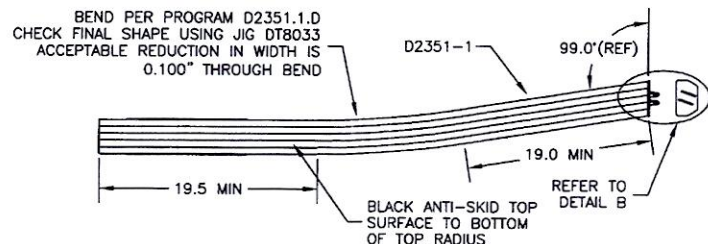
GENERAL NOTES

- 1) WELD PER DART QSI 004
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5 CHAMFER D2244 EXTRUSION 0.075"x45" BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP



D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



RELEASED
05.11.28

UNDER REVIEW

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DESIGN KE	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E
DATE 05.11.14	TITLE HIGH FLOAT STEP ASSEMBLY	SHEET 2 OF 2	SCALE 1:12

5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Hel-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Hel-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Hel-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2946	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Hel-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Hel-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Hel-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Hel-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT